

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

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REV3 987 06 30232
DRG No.

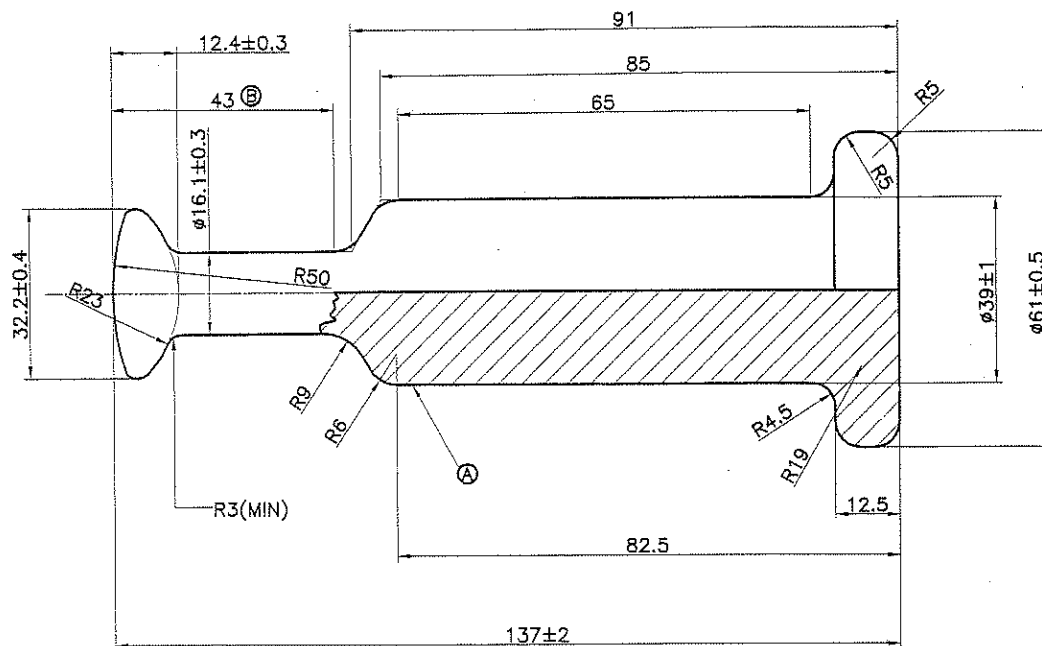
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SIGN AND DATE
REF. DRG. No.

SIGN AND DATE

INVENTORY No.

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED			CHECKED



NOTES :

- 1 BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- 2 MATERIAL TO CONFORM TO PURCHASING SPEC. ELIPS:3600103
- 3 SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- 4 SEQUENCE OF OPERATIONS :
 - A) BALL FITTINGS ARE NORMALISED AFTER FORING
 - B) HARDENING & TEMPERING AND SHOT BLASTING
- 5 BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION 4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (16 mm 'B' DESIGNATION) UPTO PORTION (B)
- 6 BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 KN
- 7 MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS

CONTROLLED COPY



BHARAT HEAVY ELECTRICALS LTD;
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

DEPT	GRADE OF TOL DIM		SCALE N T S	WEIGHT (kg) 1.0	REF TO ASSY.DRG	ITEM No.	No. OF ITEMS
CODE	C/M/F		(Approx)				
TITLE BALL FITTING PRE BORING STAGE FOR 70-90KN COMPOSITE LONG ROD INSULATOR				CARD CODE	DRAWING No.		REV.
					3 987 06 30232		00
							No. OF SHEETS

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm.

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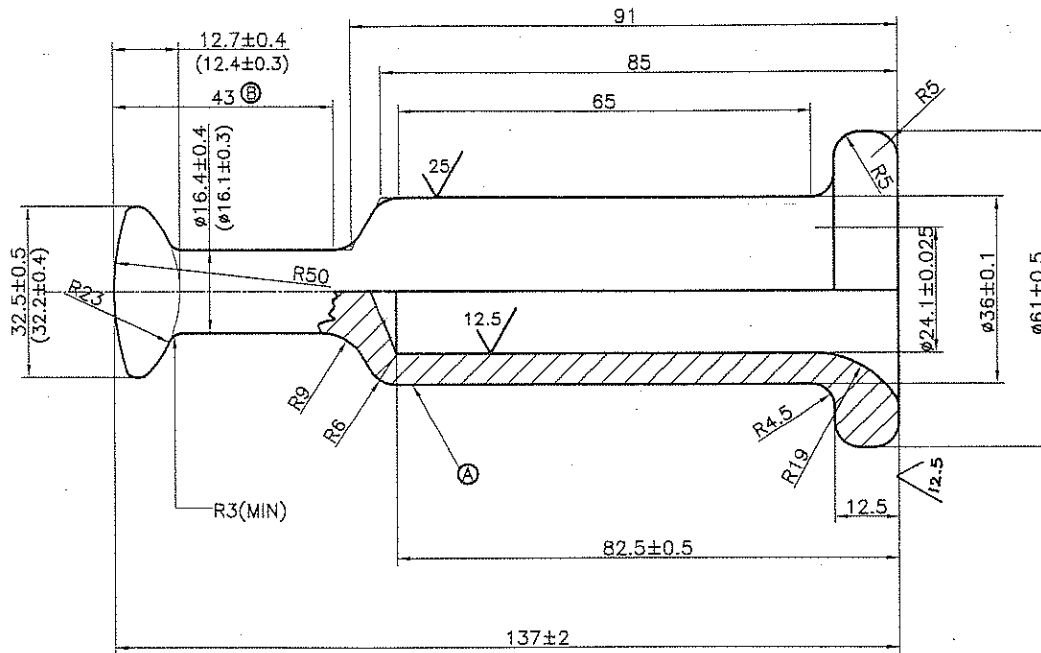
SIGN AND DATE
REF. DRG. No.

INVENTORY No.

REV

3 987 06 30222

DRG No.



NOTES :

- ALL DIMENSIONS ARE AFTER HOT- DIP GALVANISING
A THICKNESS OF 0.15 mm MAY BE ASSUMED FOR GALVANISING
- DIMENSIONS INDICATED IN BRACKET REFERS TO BEFORE GALVANISING STAGE
- BALL FITTINGS ARE TO BE MADE BY FORGING PROCESS ONLY
- MATERIAL TO CONFORM TO PURCHASING SPEC. EL:PS:3600103
- IF THE FORGING SURFACE IS NOT SMOOTH AT THE PORTION (B) & (C)
BALL FITTINGS ARE TO BE MACHINED AT THAT PLACE WITH HELP OF A 'FORM TOOL' TO GET A SMOOTH SURFACE
- AFTER GALVANISING THE BALL PORTION SHOULD ANSWER TO ALL THE RELAVANT "GO AND NO GO" GAUGES RECOMMENDED BY IEC Pub.60120 OR LATEST (16 mm DESIGNATION) UP TO PORTION (B)
- SUPPLIER'S IDENTIFICATION MARK & RATING SHALL BE PROVIDED IN DEPRESSED FORM IN 6 mm LETTER SIZE AT PLACE SHOWN AS (A)
- SEQUENCE OF OPERATIONS :
A) BALL FITTINGS ARE NORMALISED AFTER FORING
B) MACHINING (IF NECESSARY SEE NOTE No. 5)
C) HARDENING & TEMPERING AND SHOT BLASTING
D) GALVANISING
E) BORING
- BEFORE GALVANISING THE BALL PORTION SHOULD ANSWER TO "GO AND NO GO" GAUGES TO DRG. No. 4 SK 0260 LATEST REVISION 4 SK 0261 LATEST REVISION AND CLAUSES B7,B8 & B9 OF IEC Pub. 60120 (16 mm DESIGNATION) UPTO PORTION (B)
- BALL FITTING SHALL WITHSTAND A MINIMUM TENSILE STRENGTH OF 113 kN
- MPI TEST TO BE CARRIED OUT ON ALL FORGED FITTINGS
- BORE HAS TO BE DONE ONLY AFTER GALVANISING
- DIM $\phi 24.1 \pm 0.025$ TO BE CHECKED BY "GO & NO GO" GAUGES.
- THE WEIGHT OF FORGED BALL FITTING AT BLACK STAGE IS 1.0 kg (APPROX)
- DIM 82.5 ± 0.5 TO BE CHECKED BY "GO & NO GO" GAUGES OF DRG. No. 4 SK 2719

COPY

BHARAT HEAVY ELECTRICALS LTD. ELECTROPORCELAINS DIVISION BANGALORE 560 012				NAME N.CHIKKANNA		SIGN 		DATE 04/02/11	
DEPT CODE				GRADE OF TOL DIM C/M/F		SCALE N T S		WEIGHT (kg) 0.7 (Approx)	
REF TO ASSY.DRG				ITEM No.		No. OF ITEMS			
TITLE BALL FITTING FOR 70/90 kN COMPOSITE LONG ROD INSULATOR				CARD CODE No.		DRAWING No. 3 987 06 30222		REV. 01	
						No. OF SHEETS			

- | REV | DATE | ALTERED | REV | DATE | ALTERED |
|-----|----------|---------|-----|------|---------|
| 01 | 04/02/11 | CHECKED | | | |
- DRAWING REDRAWN & REVISED
 - DIM 82.5 ± 0.5 WAS 82.5
 - NOTE NO. 15 ADDED
- REFER TO PH No.5429

SUPERSEDES DRG. No.

SHT.24 SIZE A3 420 x 297